

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025653**Date Inspected:** 20-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

CWI Inspector: Mr. Li Yang

This QA Inspector observed ZPMC welder Mr. Xu Naisheng, stencil 044541 used shielded metal arc welding procedure specification WPS-B-T-4341-TC-U4B-1 to perform OBG segment 13W welds DP3153-001-007 and 008. This QA Inspector observed that Xu Naisheng appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhang Feng, stencil 049769 used shielded metal arc welding procedure specification WPS-345-SMAW-3G(3F)-FCM-Repair-1 to perform repairs of OBG segment 13W FL3 welds that had been visually rejected. This QA Inspector observed that Mr. Zhang Feng appeared to be certified to make these weld repairs and that the base materials had been preheated with a torch. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Sun Gusong stencil 058592 used shielded metal arc welding procedure specification WPS-B-P-2114-TC-U4B-FCM-1 to complete OBG segment 13AE tack weld DP3082-001-029 and 030. This QA Inspector observed Mr. Sun Gusong appeared to be certified to make these

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welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Zhengbin, stencil 216086 used shielded metal arc welding procedure specification WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 13E welds SEG3019*-001-065 and 067. This QA Inspector observed Wang Zhengbin appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yu Hui Ye, stencil 045143 used flux cored welding procedure specification WPS-B-T-2233-ESAB to perform OBG segment 13CW weld SEG3015U-069. This QA Inspector observed that Mr. Yu Hui Ye appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Chang Ming, stencil 047864 used shielded metal arc welding procedure specification WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 13E welds SEG3013AA*-001-057 and 058. This QA Inspector observed Wang Chang Ming appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
